



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4148-1

Job Sheet 163021



Part No: D4148-1

Job Qty: 20 ea

Part Name: Crosstube Lug Plate, Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.10.29 as per revC DD verf:EC
IPP REV:C 11.03.02 AS PER DWG REV.D DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/14/17	11/14/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	20 pcs	11/15/17	11/15/17	0.06	4.31	Waterjet1		SC
110	QC	20 pcs	11/15/17	11/15/17	0.00	0.00	QC2		SC
120	QC	20 pcs	11/15/17	11/15/17	0.00	0.00	QC8		SC
150	Packaging	20 pcs	11/15/17	11/15/17	0.00	0.00	Packaging3		SC
160	QC21-SA	20 Ea	11/15/17	11/15/17	0.00	0.00	QC21		SC

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	7	141	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Crosstube Lug Plate	0.129Inches + 0.005 - 0.001	0.134 0.128		
2	Fwd Crosstube Lug Plate	0.191Inches + 0.005 - 0.001	0.196 0.190		
3	Fwd Crosstube Lug Plate	0.380Inches + 0.006 - 0.001	0.386 0.379		
4	Fwd Crosstube Lug Plate	0.257Inches + 0.006 - 0.001	0.263 0.256		
5	Fwd Crosstube Lug Plate	0.500Inches + 0.008 - 0.001	0.508 0.499		
6	Fwd Crosstube Lug Plate	0.940Inches ± 0.030	0.970 0.910		
7	Fwd Crosstube Lug Plate	4.470Inches ± 0.030	4.500 4.440		
8	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740		
9	Fwd Crosstube Lug Plate	8.470Inches ± 0.030	8.500 8.440		
10	Fwd Crosstube Lug Plate	8.096Inches ± 0.010	8.106 8.086		

DART
AEROSPACE
S011031



Crosstube Lug Plate, Fwd

PART NO: D4148-1

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/17/17

Job No: 163021

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

11	Fwd Crosstube Lug Plate	5.430Inches ± 0.030	5.460 5.400
12	Fwd Crosstube Lug Plate	5.197Inches ± 0.010	5.207 5.187
13	Fwd Crosstube Lug Plate	4.733Inches ± 0.010	4.743 4.723
14	Fwd Crosstube Lug Plate	0.310Inches ± 0.010	0.320 0.300
15	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740
16	Fwd Crosstube Lug Plate	0.375Inches ± 0.010	0.385 0.365
17	Fwd Crosstube Lug Plate	1.840Inches ± 0.030	1.870 1.810
18	Fwd Crosstube Lug Plate	0.920Inches ± 0.030	0.950 0.890
19	Fwd Crosstube Lug Plate	3.000Inches ± 0.010	3.010 2.990
20	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740
21	Fwd Crosstube Lug Plate	0.625Inches ± 0.010	0.635 0.615
22	Fwd Crosstube Lug Plate	1.982Inches ± 0.010	1.992 1.972
23	Fwd Crosstube Lug Plate	0.991Inches ± 0.010	1.001 0.981
24	Fwd Crosstube Lug Plate	0.770Inches ± 0.030	0.800 0.740
25	Fwd Crosstube Lug Plate	1.540Inches ± 0.030	1.570 1.510
26	Fwd Crosstube Lug Plate	2.470Inches ± 0.030	2.500 2.440
27	Fwd Crosstube Lug Plate	0.820Inches ± 0.030	0.850 0.790
28	Fwd Crosstube Lug Plate	3.570Inches ± 0.030	3.600 3.540
29	Fwd Crosstube Lug Plate	1.230Inches ± 0.030	1.260 1.200
30	Fwd Crosstube Lug Plate	0.730Inches ± 0.030	0.760 0.700
31	Fwd Crosstube Lug Plate	0.125Inches ± 0.010	0.135 0.115
32	Fwd Crosstube Lug Plate	0.252Inches + 0.030 - 0.000	0.282 0.252

Plex 11/7/17 1:17 PM dart.Michaud-Febrille.Victoria

DART AEROSPACE LTD		Work Order:	163021
Description: Fwd Crosstube Lug Plate		Part Number:	D4148-1
Inspection Dwg: D4148 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø0.130			VDI-82	
Ø0.191	+0.005/-0.001	Ø0.192			1qpe	
Ø0.38	+0.006/-0.001	Ø0.383				
Ø0.257	+0.006/-0.001	Ø0.258				
Ø0.50	+0.008/-0.001	Ø0.501				
0.94	+/-0.030	0.95				
4.47	+/-0.030	4.478				
0.750	+/-0.010	0.751				
8.47	+/-0.030	8.476				
8.096	+/-0.010	8.097				
5.43	+/-0.030	5.44				
5.197	+/-0.010	5.198				
4.733	+/-0.010	4.732				
0.310	+/-0.010	0.309				
0.750	+/-0.010	0.750				
0.375	+/-0.010	0.376				
1.84	+/-0.030	1.85				
0.92	+/-0.030	0.93				
3.000	+/-0.010	3.000				
0.750	+/-0.010	0.749				
0.625	+/-0.010	0.624				
1.982	+/-0.010	1.983				
0.991	+/-0.010	0.990				
0.77	+/-0.030	0.78				
1.54	+/-0.030	1.55				
2.47	+/-0.030	2.476				
0.82	+/-0.030	0.825				
3.57	+/-0.030	3.58				
1.23	+/-0.030	1.24				
0.73	+/-0.030	0.739				
0.125	+/-0.010	0.117				
Ø0.252	+0.003/-0.000	Ø0.253				

Measured by:	SC	Audited by:	38	Preliminary Approval:	
Date:	17/11/15	Date:	NOV 20 2017	Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	
F	13.11.26	Dwg Rev updated	KJ	